







Date: Wednesday, 02/04/2008 11:27:35 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 38299		
Estimate Number	: 12687		
P.O. Number	:	Part Number	: D35711
This Issue	: 02/04/2008 S.O. No. :	Drawing Number	: D3571 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 38086	Material	:
Written By	:	Due Date	: 14/04/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JD 08 04 08</u>		
Comment	: Est Rev:A New Issue 07-02-01 JLM		

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"	
	Comment: Qty.: 0.2531 f(s)/Unit Total : 5.0610 f(s) 6061-T6 Bar .75" X 1.5" Batch: <u>M10Y326</u> <u>SA</u>		
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW Cut blank 2.90 " long <u>SA 08/04/05</u> (20)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA675Rev: <u>A</u> & Dwg D3571 Rev: <u>A</u> 2-Deburr per dwg D3571 <u>SA 08/04/05</u> (19) (110)		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 08/04/05</u> (19)		
5.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK <u>SA 08/04/06</u> (19)		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3571-1 PAR #: N/A Fault Category: Prod/Machined Part NCR: Yes No DQA: D Date: 08/04/15
D412-702 QA: N/C Closed: D Date: 08/04/15

NCR: <u>38299</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/04/05</u>	<u>3.0</u>	<u>-1 part scrap. C-sink offset by .030. Programming error</u>	<u>[Signature]</u> <u>08/04/12</u>	<u>Fix program Scrap and Rebuild and replace at 110</u>	<u>[Signature]</u> <u>08/04/05</u>	<u>[Signature]</u> <u>08/04/07</u>	<u>[Signature]</u> <u>08/04/12</u>	<u>[Signature]</u> <u>08/04/07</u>
				<u>no mkt.</u>				

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 38299

Part Number: D35711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/04/07 (19)

7.0

POWDER COATING

POWDER COATING



M 106 442



(19X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-6 08/04/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-09 (X19)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 57244

PC 8/4/10

(19)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-10

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38299
Description: Guide		Part Number: D3571-1
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.698	/			
Ø1.00 Depth 100	+/-0.010	Ø.99 x 100	/			
2.75	+/-0.030	2.752	/			
1.38	+/-0.030	1.375	/			
1.25	+/-0.030	1.278	/			
0.63	+/-0.010	.060	/			
0.031 chamfer	+/-0.010	0.030	/			
Ø0.500	+0.006/-0.001	Ø.500	/			
Ø0.201	+0.005/-0.001	Ø.203	/			
R0.25	+/-0.030	R.25	/			
0.260	+0.000/-0.010	.259	/			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø.385 x 100°	/			
0.125	+/-0.010	.126	/			
2.250	+/-0.010	2.247	/			
0.250	+/-0.010	.251	/			
0.188	+/-0.010	.189	/			
0.063 chamfer	+/-0.010	.060	/			

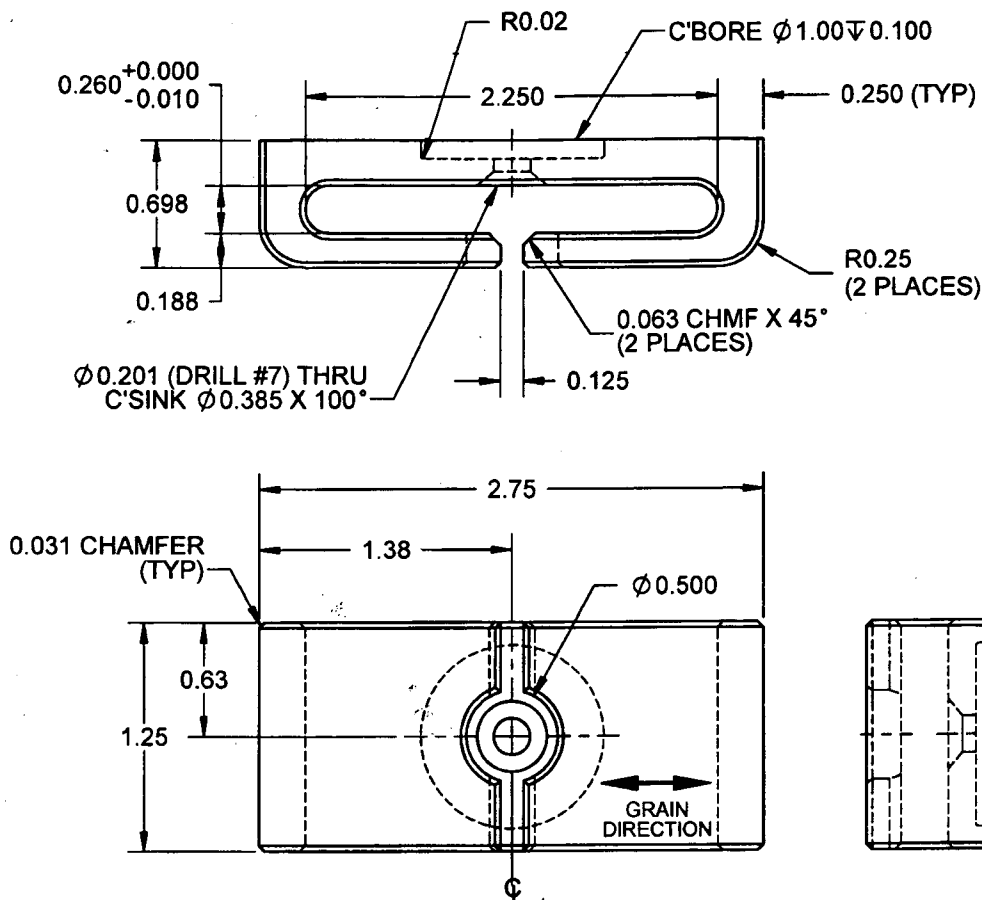
Measured by: SA	Audited by: SF	Prototype Approval:	N/A
Date: 08/04/05	Date: 08/04/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	

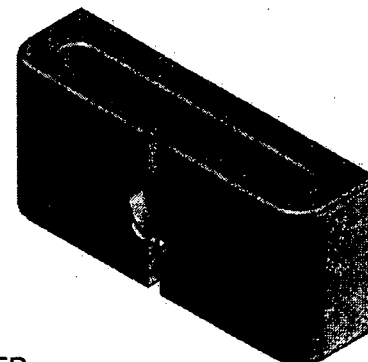
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WITHOUT NOTICE
WORK ORDER
NO. 38299

DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571
DATE 07.01.29	TITLE GUIDE	REV. A SHEET 1 OF 2 SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE

RELEASED07.04.12 *[Signature]***D3571-1 GUIDE**

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**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

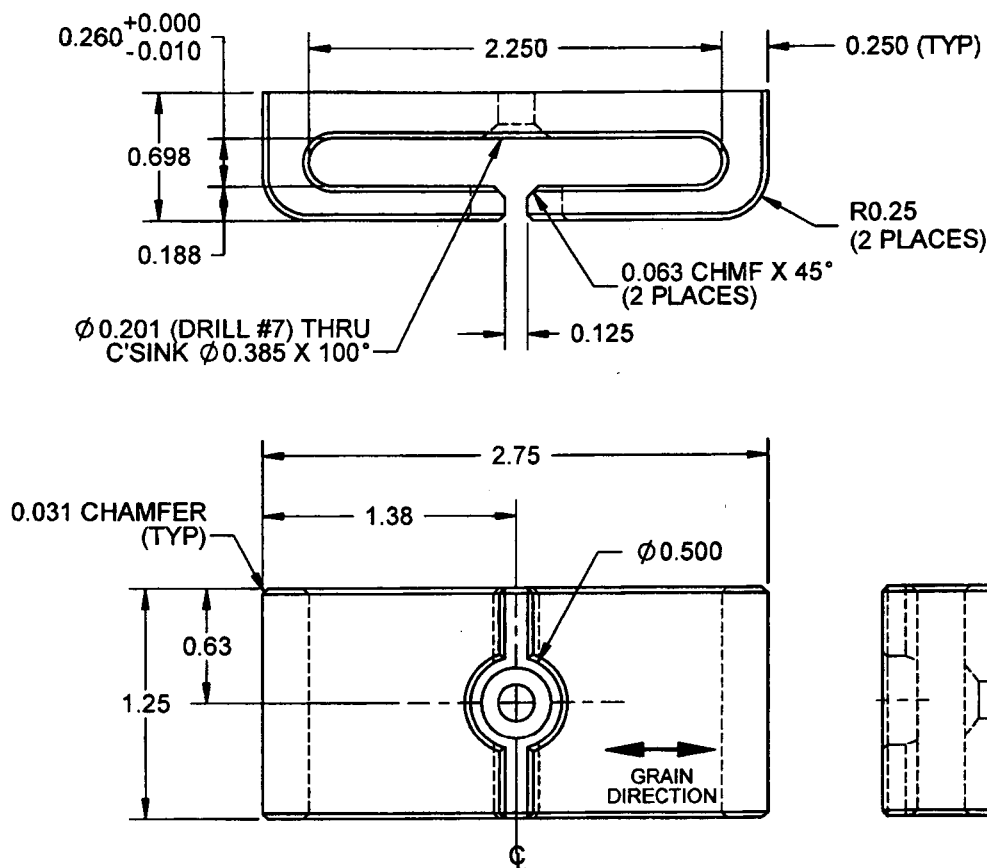
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DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 07.01.29		TITLE GUIDE	SCALE 1:1

RELEASED
07.04.12 *[Signature]*

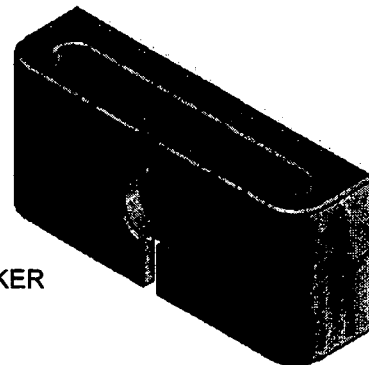


D3571-3 GUIDE

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WORK ORDER
NO. 38299

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



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